



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

April 27
D3608-3

Job Sheet 175145



Part No: D3608-3

Job Qty: 10 ea

Part Name: Upper Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07-03-26 JLM IPP Rev:B 08-10-15 preliminary issue DD verified by:EC IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E 10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as per revC dwg DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/26/18	4/26/18	0.00	0.00	Start Up Waterjet		<i>dc 18/04/07</i>
100	Waterjet	10 pcs	4/27/18	4/27/18	0.03	1.46	Waterjet1		<i>dc 18/04/07</i>
110	QC	10 pcs	4/27/18	4/27/18	0.00	0.00	QC2 Waterjet-2		<i>dc 18/04/07</i>
120	QC	10 pcs	4/27/18	4/27/18	0.00	0.00	QC8-3		<i>APR 30 2018</i>
150	Packaging	10 pcs	4/27/18	4/27/18	0.00	0.00	Packaging3	<i>51504</i>	<i>APR 17 2018</i>
160	QC21-SA	10 Ea	4/27/18	4/27/18	0.00	0.00	QC21		<i>DAS 21 APR 18 2018</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	7.3920 sf (.7392 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	7	262	0

Part Specifications

Specifications could not be found.

Plex 3/28/18 7:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description V _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐															
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Composite ☐	Supplier ☐																
		MRB (QSI042) Approval															
		Completed By															
		Lead hand / Supervisor Approval Verification															
		QC / QA Coordinator Approval															

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 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaero.com

Container No: S059053
Part: D3608-3
Job No: 175145
Serial No/Batch: S059053
Revision:
Inspector:

Date: 04/08/18

Root Cause			
Environment	☐	No Re-v	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Bernoulli Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Detect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	ss/Surge gram Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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OTHER : _____

DART AEROSPACE LTD		Work Order:	
Description: Upper Doubler		Part Number:	D3608-3
Inspection Dwg: D3608	Rev: <i>ED</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	<i>Ø.101</i>	<i>1</i>		<i>V: 0.001</i>	
1.82	+/-0.030	<i>1.82</i>	<i>1</i>		<i>Tap</i>	
0.50	+/-0.030	<i>.50</i>	<i>1</i>			
11.50	+/-0.030	<i>11.50</i>	<i>1</i>			
7.950	+/-0.010	<i>7.946</i>	<i>1</i>			
<i>325</i> 1.325	+/-0.010	<i>1.322</i>	<i>1</i>			
2.25	+/-0.030	<i>2.25</i>	<i>1</i>			
8.50	+/-0.030	<i>8.50</i>	<i>1</i>			
3.750	+/-0.010	<i>3.749</i>	<i>1</i>			
1.250	+/-0.010	<i>1.249</i>	<i>1</i>			
6.82	+/-0.030	<i>6.82</i>	<i>1</i>			
2.46	+/-0.030	<i>2.46</i>	<i>1</i>			
7.07	+/-0.030	<i>7.07</i>	<i>1</i>			
11.63	+/-0.030	<i>11.63</i>	<i>1</i>			
2.28	+/-0.030	<i>2.28</i>	<i>1</i>			
1.44	+/-0.030	<i>1.44</i>	<i>1</i>			
8.56	+/-0.030	<i>8.56</i>	<i>1</i>			
2.00	+/-0.030	<i>2.00</i>	<i>1</i>			
0.040	+/-0.010	<i>.034</i>	<i>1</i>			

Measured by:	<i>DC</i>	Audited by:	<i>DAS 38</i>	Preliminary Approval:	
Date:	<i>18/04/07</i>	Date:	<i>APR 11 2018</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>